

Date: Tuesday, 12/18/2007 10:45:51 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPRING		
Job Number	: 36397					
Estimate Number	: 10497					
P.O. Number	: N/A		Part Number	: D2535		
This Issue	12/18/2007	S.O. No. : N/A	Drawing Number	: D2535 REV. A		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: A		
Previous Run	: 34590		Material	: N/A		
Written By	: J.A.		Due Date	: 12/31/2007		
Checked & Approved By	: J.A. 07.12.18		Qty:	50	Um:	Each
Comment	: Est. A 99.04.19 New Issue (From hand written IPP) DM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING 
		Comment: PURCHASING Issue P/O: 5017 <i>CL07/12/19</i> <i>50</i> Possible Supplier: Victoria Spring, 0.070 SS Torsion Spring
2.0	D2535P	Spring 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) SPRING
3.0	PACKAGING 1	PACKAGING RESOURCE #1 
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached <i>CL 7/12/21 50</i>
4.0	QC6	DIMENSIONAL CHECK 
		Comment: DIMENSIONAL CHECK Check dims to dwg <i>CL 12/12/04 450</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1 
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST 36 <i>AS 07/12/27 50</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/01/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



25

Comment: FINAL INSPECTION/W/O RELEASE

12/08/07

Job Completion



2008/12

W

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

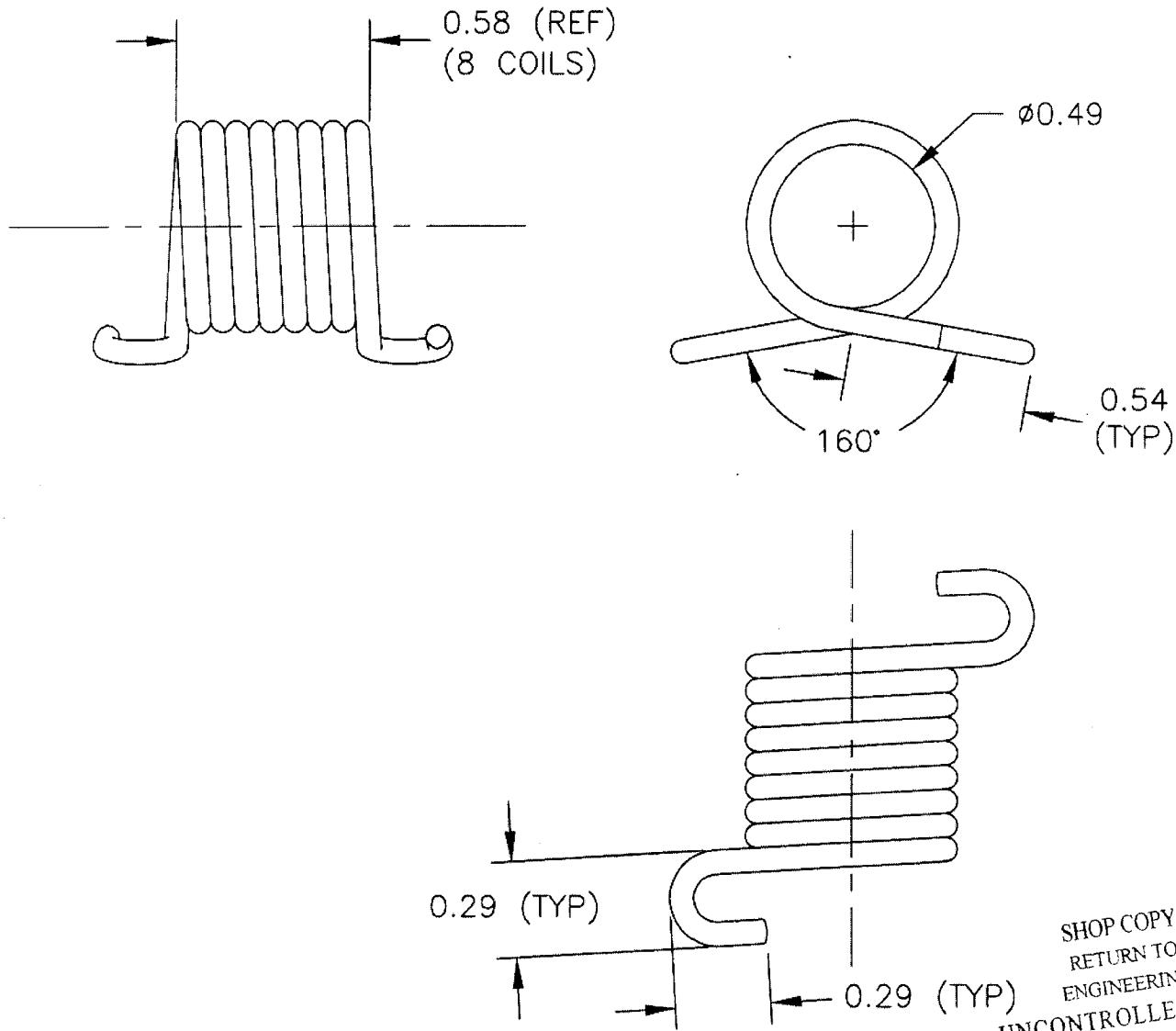
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTCOPY ISSUE
GE

DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED JH	DRAWING NO. D2535	REV. A SHEET 1 OF 1
DATE 99.04.08		TITLE SPRING SPEC CONTROL	SCALE 2:1
A	99.04.08	NEW ISSUE	

RELEASED
99.05.11 KE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36397

SPECIFICATION CONTROL DRAWING

TENSION SPRING WITH 8 COILS (NO GAP BETWEEN COILS)

MATERIAL: AISI STAINLESS STEEL Ø0.070

POSSIBLE SUPPLIERS: VICTORIA SPRINGS, P/N .070SS TENSION SPRING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

INVOICE 17764

Victory Spring Ltd.

#2 6104 - 82 Ave, Edmonton AB T6B 0E7
Tel: (780) 442-4020 · Fax: (30) 468-1946

PRECISION COIL SPRINGS AND WIRE FORMS

BILL TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawkesbury ON K A 1K7

SHIP TO:

DATE	ORDER No.	SHIP VIA			
20-Dec-07	5317	Fed Ex 151793240			
QUANTITY	DESCRIPTION	UNIT	AMOUNT		
50	D2535F Torsion Spring	4.56	228.00		
GST #	TERMS	SUBTOTAL	FREIGHT	GST	TOTAL
854454527	NET 30 DAYS	228.00		13.68	241.68

Thank you!
WE APPRECIATE YOUR BUSINESS

Victory Spring Ltd.

#2, 6104 - 82 Ave Edmonton, AB T6B 0E
Tel: (780) 442-4020 Fax (780) 466-8000

CONFORMANCE REPORT

REPORT FOR: Dart Aerospace Ltd.		DATE: 12/20/2007
PO # <u>5317</u> <u>5017</u>	PART/DRAWING #: D2535P	
SPRING DESCRIPTION: Torsion Spring		QUANTITY: 50

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS T302	Yes	
Material diameter	0.070"	Yes	
I.D.	.490"	0.495	
O.D.			
Number of Coils	8 Ref.	Yes	
Free Length			
Helix	RHW	Yes	
End type	As per dwg.		
Rate (lb/in)			
Finish			

COMMENTS

Mill Certificate attached: N
Material Heat Number: N/A

Certified by: Jeremy Burrowes